



Dart Aerospace Ltd.
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D2620**Job Sheet 208532****Part No:** D2620**Job Qty:** 8 pcs**Part Name:** Skidtube, 206 Skidtube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/23/20**Job Tracking No:****Due Date:** 4/20/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Skidtubes - Bend - 1	8 pcs	4/20/20	4/20/20	0.00	2.11	Skidtubes - Bend		<i>MLA</i> DAS 03 9-89
110	QC 5	8 pcs	4/20/20	4/20/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	8 pcs	4/20/20	4/20/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



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Container No: S269849**Part:** D2620**Job No:** 208532**Serial No/Batch:** S269849**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 04/09/20

		Packaging 3 - 12 - B4B					
		Packaging 3 - 13 - B4B					
		Packaging 3 - 14 - B4B					
		Packaging 3 - 15 - B4B					
		Packaging 3 - 16 - B4B					
		Packaging 3 - 17 - B4B					
		Packaging 3 - 18 - B4B					
		Packaging 3 - 19 - B4B					
		Packaging 3 - 20 - B4B					
		Packaging 3 - 21 - B4B					
		Packaging 3 - 22 - B4B					
		Packaging 3 - 23 - B4B					
		Packaging 3 - 24 - B4B					
		Packaging 3 - 25 - B4B					
		Packaging 3 - 26 - B4B	Make				
		Packaging 3 - 27 - B4B					
		Packaging 3 - 28 - B4B					
		Packaging 3 - 29 - B4B					
		Packaging 3 - 30 - B4B					
		Packaging 3 - 31 - B4B					
		Packaging 3 - 32 - B4B					
		Packaging 3 - 33 - B4B					
		Packaging 3 - 34 - B4B					
		Packaging 3 - 35 - B4B					
		Packaging 3 - 36 - B4B					
		Packaging 3 - 37 - B4B					
		130 QC 21 - SA	8 pcs	4/20/20	0.00 0.00	QC 21 - SA - 21	
						QC 21 - SA - 70	DAS 21
						QC 21 - SA - 53	APR 09 2020

DAS
21
0-00

APR 09 2020

Part Op 100 - Skidtubes - 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2-
 Descriptions: Cut Fwd end of tube as per Dwg D2620
 110 - QC5- Inspect part completeness to step on W/O)
 120 - Identify as per dwg & Stock Location: LG002 LOCATION : LG002
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-160	Extrusion Round 3" 206	8 pcs (1 ea)	100-Skidtubes - Bend - 1	5236156

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - Bend - 1	D2600-1-160	8	116	0

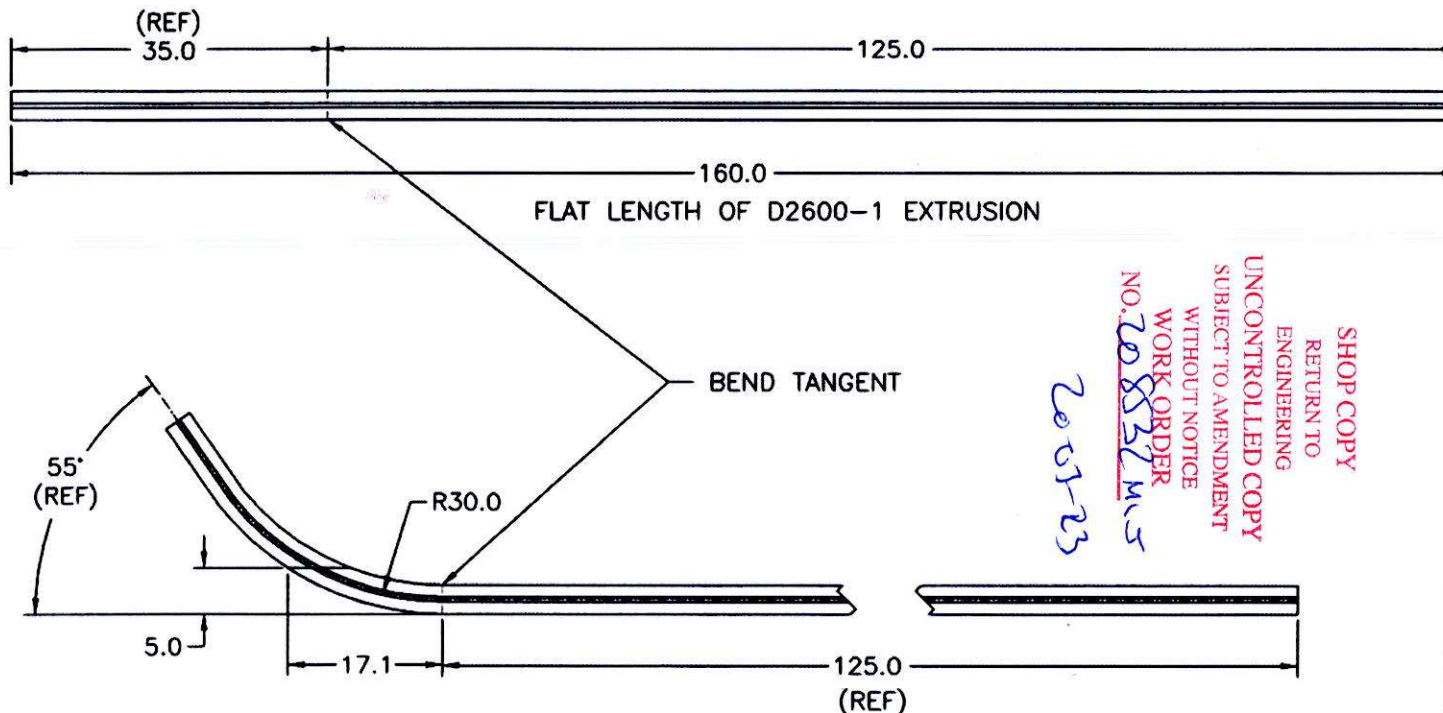
Part Specifications

Specifications could not be found.

Plex 3/23/20 8:21 AM Dart.lajeunesse.marie

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	RF	APPROVED	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	TITLE	206 SKIDTUBE BENDING CONTROL	REV. B
				SHEET 1 OF 1
				SCALE 1:20
A	97.11.07	NEW ISSUE		
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		

RELEASED
44.04.15 DS

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					